

20-8767



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SCRAP

D3137-043
Job Sheet 190222



Part No: D3137-043

Job Qty: 6 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 2/25/19

Created By: Marie Lajeunesse

Type: SOLD *slh*

Description:

Note: DWG REV F IPP Rev:A 04.02.18 New issue KJ/DS IPP Rev B 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	2/25/19	2/25/19	0.00	0.14	Bandsaw - 1		<i>slh</i>
110	HAAS 4 Axis - B4B	6 pcs	2/25/19	2/25/19	0.00	11.11	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		<i>slh Kf.</i>
120	QC 2	6 pcs	2/25/19	2/25/19	0.00	0.00	QC 2 - 1		<i>Kf 2019-03-01</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		

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Container No: S157124



Part: D3137-043

Job No: 190222

Serial No/Batch: S157124

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/27/19

130 QC 8	6 pcs	2/25/19	0.00	0.00	QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	Do 19-03-24
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
140 Small Fab - 2 - B4B	6 pcs	2/25/19	0.00	0.33	Small Fab - 1 - B4B	DAS 50 MAR 26 2019 9-59
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150 QC 5	6 pcs	2/25/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS 40 MAR 27 2019 9-59
					QC 5 - 50	
					QC 5 - 30	
160 Packaging 3-1 - Stock - B4B	6 pcs	2/25/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 9-59
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				QC 21 - SA - 21	0.00
				QC 21 - SA - 70	0.00
				QC 21 - SA - 53	0.00
170 QC 21 - SA	6 pcs	2/25/19	0.00 0.00		

Part Op 100 - Bandsaw - Cut blanks: (.500" x 2.000") 5.570" long
 Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Small Fab - Assemble D3137-043 as per Dwg D3137
 150 - QC5- Inspect part completeness to step on W/O
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B0.500X2.000	17-4 SS Bar .500 x 2.00	2.5800 ft (.43 ea)	100-Bandsaw - 1	5072711
D3137-3	Guide	6 pcs (1 ea)	140-Small Fab - 2 - B4B	5152166
D3137-5	Washer	6 pcs (1 ea)	140-Small Fab - 2 - B4B	5160921
MS24694-S101	Screw	6 Ea (1 ea)	140-Small Fab - 2 - B4B	fm129999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B0.500X2.000	3	20	0
140-Small Fab - 2 - B4B	D3137-3	6	5	0
	D3137-5	6	6	0
	MS24694-S101	6	18	0

Part Specifications

Specifications could not be found.

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DEC 11 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8767

Route update only

Job: 190222.		DISPOSITION		DEPARTMENT/PROCESS							
Part No. 03137-043		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 2019-03-01		Sequence #: 110		QTY Affected: 1				MRB (QSI042)			
Description Work Order Deviation				Disposition				Completed By			
The thickness is under allowed tolerance Part = 0.162 ± 0.010 and I have 0.146 - I lowered the offset for the first operation and forgot to raise it back up for the second operation.				Scrap and No Replace.				19-07-17			
								Lead hand / Supervisor			
								QC / QA Coordinator			
Root Cause				FAULT CATEGORY							
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☒ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
				Other/Details:							